

Work Order ID 80592

80592

Page 1

February-23-12 2:50:50 PM

Item ID: D4276-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Beam

Start Date: 24/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: M.C.J

Date: 12/02/23 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4276

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

SL 12-02-29

(2)

Jeaspa Bandsaw

Cut Blank to 36.630"
Batch: 119346

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

SL 12-03-04

(2)

HAAS CNC vertical machine #1

1-Machine per folio FB007
DWG REV: A
FOLIO REV: AA

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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 Item Name: Aft Beam
 Start Date: 24/02/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		12-03-04		2	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		12/03/04		2	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2			12/03/05

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80592

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N900040100

Setup Start *NS1*

Stop ***NS2***

2

Cust Item ID:

2

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

145

M 120 222

Run	Time	Temp
3h30	0.00	
4h00		
320°F	0.00	

Powdercoat

Memo

Powder Coating

MASK AS PER DWG

0.00

150

Memo

0.00

QC

Quality Control

2X ~~✓~~ m ~~✓~~ 12/03/06

Identify as per dwg & Stock Location:

0.00

180

Memo

0.00

Packaging

Packaging

2x SP 12-03-6

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Revision ID: Stop ***NS2***
Item Name: Aft Beam
Start Date: 24/02/2012 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 09/03/2012 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/3/12

012-03-4

W/O:		WORK ORDER CHANGES					
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Picklist Print

February-23-12 2:50:54 PM

Page 1

Work Order ID: 80592

80592

Parent Item: D4276-1

D4276-1

Parent Item Name: Aft Beam

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD
10.12.02 AS PER DWG REV.A DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased		No		100	f	71.8628	3.052	6.425263			

M6061T6B1 000X04 000

**

SL 12-02-29

6061-T6 Bar 1.00 x 4.00

Location

Loc Qty

Loc Code

MAT004

24

116808

0.787

118400

15.003

119346

12.504

119513

7.5688

120243

12

120603

24

6.43

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DART AEROSPACE LTD		Work Order: 80592
Description: Aft Beam		Part Number: D4276-1
Inspection Dwg: D4276	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.749	/		Vern	SL-3
20.500	+/-0.010	20.500	/		m-tape	
Ø0.381	+0.000/-0.001	.381	/		gauge pins	
14.380	+/-0.010	14.380	/		H-g	
R0.75	+/-0.030	.75	/			
3.50	+/-0.030	3.500	/		Vern	SL-3
16.38	+/-0.030	16.375	/		m-tape	
5.00	+/-0.030	5.00	/		Vern	SL-3
0.75	+/-0.030	.750	/		-	
2.75	+/-0.030	2.751	/		-	
3.00	+/-0.030	3.000	/		-	
1.250	+/-0.010	1.249	/		-	
4.50	+/-0.030	4.50	/		-	
0.734	+/-0.010	.735	/		-	
0.108	+/-0.010	.109	/		H-g	
36.38	+/-0.030	36.38	/		m-tape	
0.95	+/-0.030	.952	/		Vern	SL-3
0.60	+/-0.030	.600	/		-	
2.70	+/-0.030	2.699	/		-	
1.10	+/-0.030	1.10	/		-	
1.25	+/-0.030	1.249	/		-	
0.75	+/-0.030	.750	/		-	
3.000	+/-0.010	3.000	/		-	
1.500	+/-0.010	1.500	/		-	
Ø0.191	+0.005/-0.001	.193	/		-	
2.300	+/-0.010	2.300	/		-	
3.50	+/-0.030	3.500	/		-	
R0.60	+/-0.030	.60	/		-	
1.70	+/-0.030	1.699	/		-	
0.65	+/-0.030	.650	/		-	

Measured by: <i>SL</i>	Audited by: <i>mf</i>	Preliminary Approval:
Date: 12-03-04	Date: 12/03/04	Date:

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

Dart Aerospace Ltd

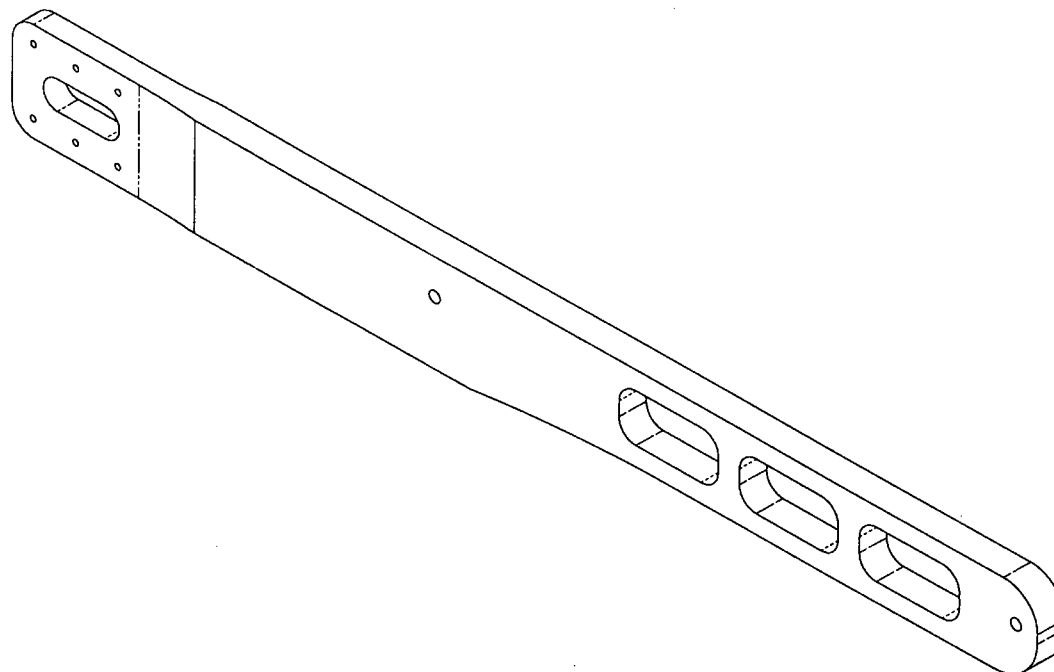
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D4276-1 AFT BEAM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.68 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

SHOP COPY
RETURN
PART NO.
UNCONTROLLED
SUBJECT
WORK
NO. **80592 H.C.J**
12/02/23

RELEASE
2010-11-30

A NEW ISSUE		SC	10.11.25
REV.	DESCRIPTION		BY DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	#	DRAWING NO.	REV. A
MFG. APPR.	#	D4276	SHEET 1 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	#	AFT BEAM	NTS
DATE	10.11.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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